

# Aero Design Ltd.

## Work Order Control Sheet

Work Order#: 2016-69 Date Opened: 09 May 2016 Title: Fabrication

Aircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket Body Product Model: Medium Quantity: 5

### Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	JC
Completed Certification (Original)	N/A
Time Sheet (R&D)	N/A
Notes	N/A

### Build Sheet Contents

Tasks Initialled	JC
Dual Inspections Initialled	JC

### Drawing List

Drawing #	Rev #	Description	Initial or N/A
76411	3	Body Assembly	JC
70406	3	Front end cutout	JC
84262	2	Basket Handle Prov.	JC

### Traveller

### Component Completion

	As Instructed
Quantity Complete on This Work Order	5
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

### Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking Tags (White) Completed	JC
Parts Placed in Stores for Distribution	JC

### Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

### Billing

Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Note:

4 w/ front end cut out

Work performed by:

Print: Andrew Bartfai

ICC / Dual Inspection performed by:

Print: Jeff Clarke

Work Order closed by:

Print: Jeff Clarke

Approved Manufacturing Facility 73-04

Sign:

Sign:

Sign:

Form 20.D/03

SCA: AD07

SCA: AD02

SCA: AD02

Date: 19-Sep-16

Date: 20-Sep-16

Date: 13-Oct-16

Rev. Original 23 Sep 2014

# CARGO BASKET BODY FABRICATION - COMMON

Work Order: 2016-69

Date Open: 09 MAY 2016

DRN AS350 MED LH  
4 with CUTOUT

Complete (initial or SCA #)  
1 & without cut out  
AD 73-04 05

## 1. Rim Assembly – Basket Body

- Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim

## 2. Weld Rim Assembly.

- Record welding rod PO on attached material list.
- 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

## 3. Inspection

- Rim for complete welds

## 4. Frame assembly – body

- General
  - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- Grind corner welds from step 2 on rim to allow hoops to sit flat.
- Pull required hoops from stock - standard, attachment, handle.
  - If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - Ensure vent hole is located at centre of tube to vent spine tubes.
- Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - Ensure correct order and orientation of hoops. Refer to drawing.
    - Attachment lugs are on inboard side.
    - Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
  - Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - Refer to applicable drawing for position, not required on some baskets.
- Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.



- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

## 5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

## 6. Inspection

- a. Frame assembly for complete welds.

## 7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require  $\frac{1}{2}$  to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{8}$ "- $\frac{3}{16}$ " down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{4}$ " down at 60 degrees.
  - iv. Fit mesh to front end of basket.



# CARGO BASKET BODY FABRICATION - COMMON

## 8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
  - i. Every intersection at top edges.
  - ii. Every intersection at ends.
  - iii. First 5 intersections down on hoops, then every second intersection.
  - iv. Every intersection along spine.
  - v. Extra large baskets – every intersection along corner.
  - vi. Every intersection around ends
  - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

AD 73-04 05	AD 73-04 05	AD 73-04 05	Complete (initial or SCA #) AD 73-04 05	AD 73-04 05
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## 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07
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## 11. Final Inspection

- To be completed by a different person than the previous steps.
- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
  - b. Filled vent holes – usually on hoops
  - c. Overall condition and conformity to drawing(s).
    - i. Hoops for height.
    - ii. Rim for width and length and alignment.
    - iii. Lid prop lugs in correct ends.
    - iv. Fore/aft strut in hoop if required by drawing.
  - d. Material lists complete.

AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02	AD 73-04 02
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**CARGO BASKET BODY FABRICATION - COMMON**

**Complete**  
(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

**12. Powder Coating**

- a. Parts are to be powder coated white in accordance with commercial practices.  
b. Record powder coating PO.  
c. Inspect powder coating on receiving.  
d. Tag basket body assembly and place into stock in preparation for assembly.

AD 73-04 02    AD 73-04 02    AD 73-04 02    AD 73-04 02    AD 73-04 02

2016-69

AS350 MED 44 (5)

CUT OUT

## CARGO BASKET BODY FABRICATION - COMMON

### General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355** – left or right

77611, Revision 1 – Short Basket

→ 76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

→ Options 70406, Revision 2 – Front end cutout – 764/776/784/940  
3 pc.

#### **Robinson R44** – left or right

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options** – Applicable to all models

70403, Revision 5 – Auxiliary Latch



Work Order: 2016-69

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Body Fabrication

1 of 2

Date Opened: 09 MAY 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>5</u>		<b>76411-01-</b> <u>02</u>	<b>Basket Assembly</b>	(-01 RH, -02 LH)	
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14099</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14099</u>
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 2		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14099/2016-22</u>
	. 1	84262	76421-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>2016-68</u>
	. 1		76422-01	Attachment Hoop (forward)		<u>2016-68</u>
	. 1		76423-01	Attachment hoop (aft)		<u>2016-47</u>
	. 4		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
	. 1		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
<b>Step 4.g.</b>		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 75")	3/4-16F Expanded Mild Steel sheet	<u>15037</u>
	. 2		--	Mesh (End - 22" x 17")	3/4-16F Expanded Mild Steel sheet	<u>15037</u>



Work Order: 2016-69Date Opened: 09 MAY 2016Material Tracking Sheet  
Eurocopter AS350 / AS355  
Medium Basket Body Fabrication

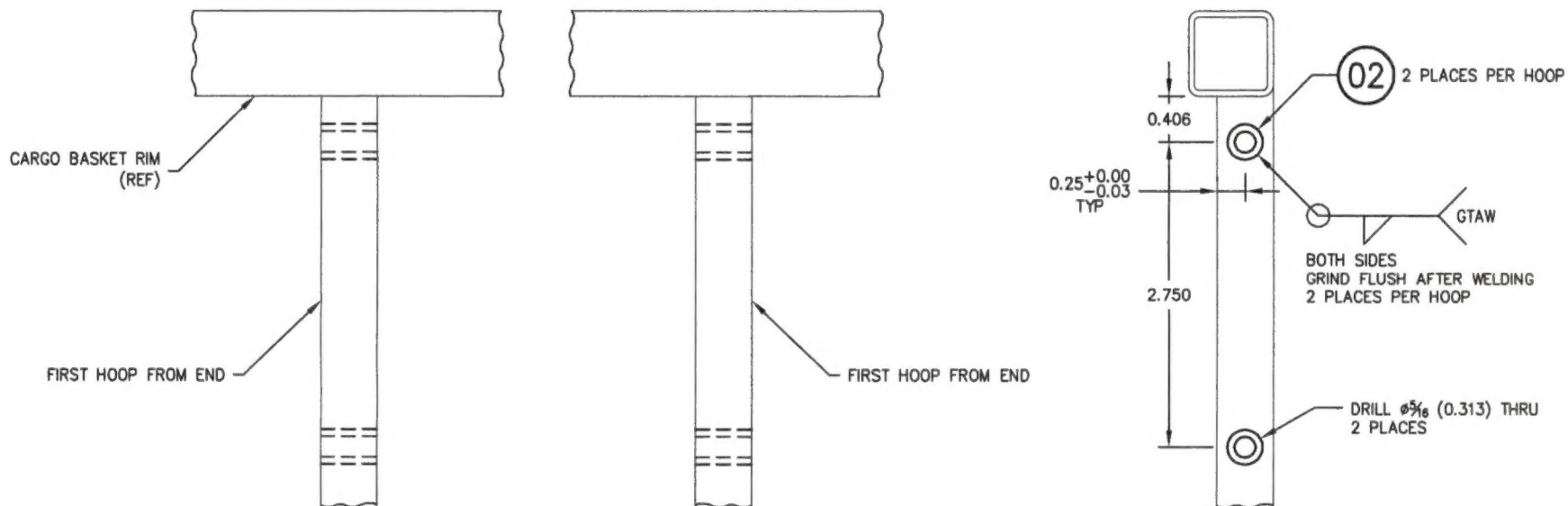
2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 8</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	15059
<b>Step 9</b>				<i>Weld Basket Components</i>		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2015-07
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 9.b.	. 1		--	Cap	1018 Mild Steel, 0.032" Sheet	9010
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				Powder Coating		

2016-69

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 38262	BJC	03/11/2009
1	CHANGE LOCATION OF BUSHINGS	BJC	29/09/2011
2	UPDATED TITLE BLOCK, MOVE LID PROVISIONS TO 84263	BJC	14/02/2014



# 01 BASKET HANDLE PROVISIONS ASSEMBLY PROVISIONS TO BE INSTALLED IN HOOPS BEFORE ASSEMBLY TO BASKET RIM

## NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ROD CONFORMING TO ER70S-2 OR EQUIVALENT.

4	84272-01	02	BUSHING
	84262-01	01	BASKET HANDLE PROV. ASSY
01	PART NO.	ITEM	DESCRIPTION
QTY	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



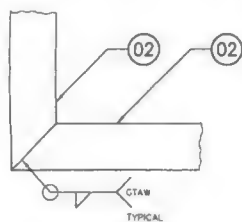
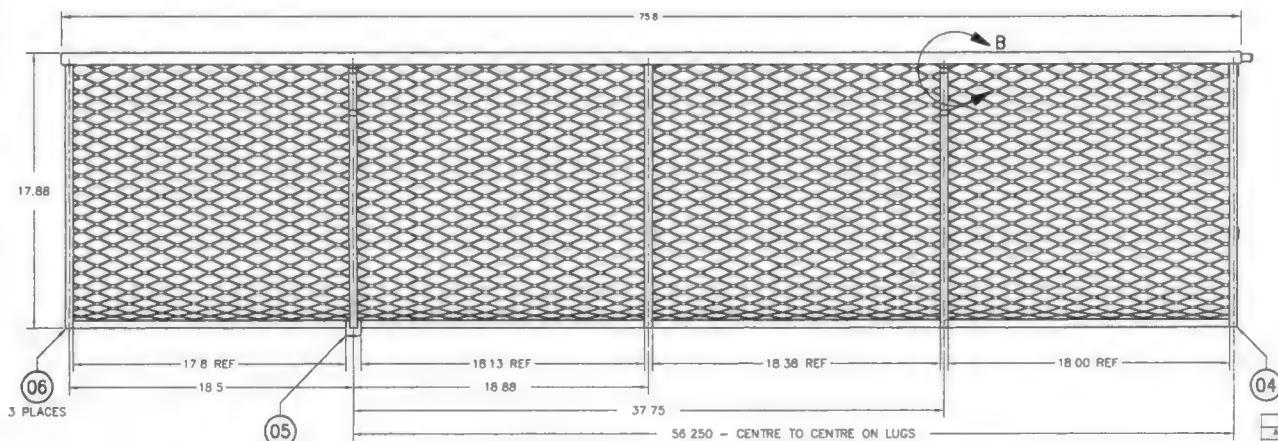
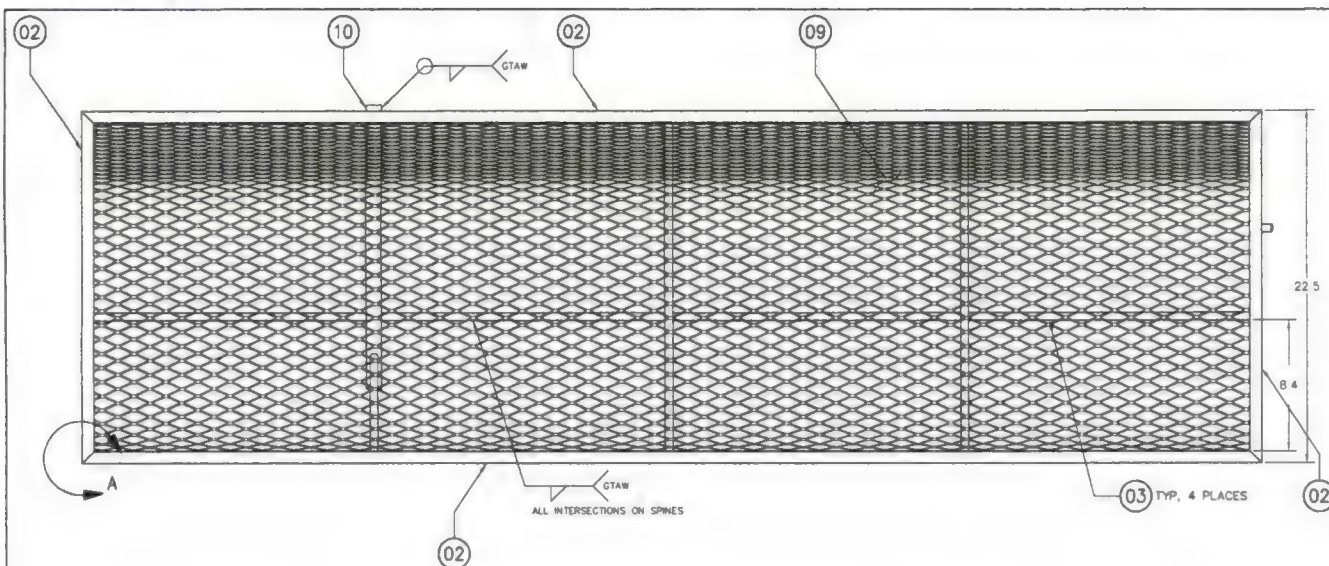
**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.488.2876 www.aerodesign.ca

HELICOPTER CARGO BASKET  
BASKET HANDLE PROVISIONS ASSEMBLY

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84262	2





DETAIL A  
SCALE 1:1

BASKET BODYASSEMBLY - RH  
SHOWN

SHOWN

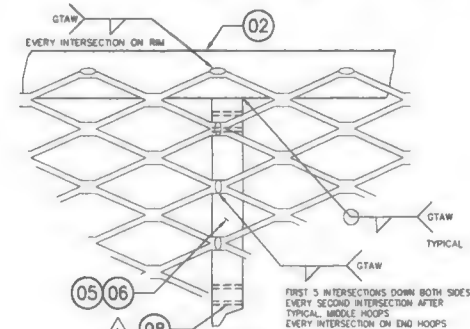
## BASKET BODY ASSEMBLY - LH

OPPOSITE

## NOTES.

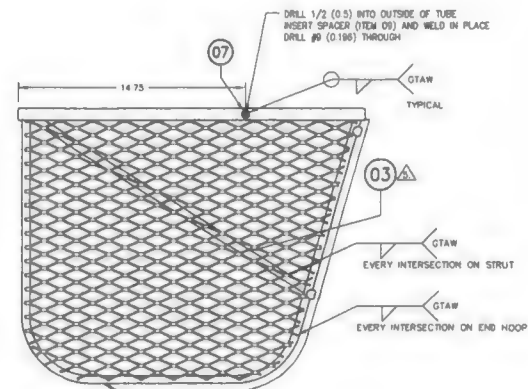
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. PRIOR TO WELDING, DRILL .30 (1/8) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETELY IN ACCORDANCE WITH AISC METHOD TO AWS, BR55.
4. 4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO E70TS-2 OR EQUIVALENT.
5. STAINLESS AND 430 STEEL WELDING ROD SHALL CONFORM TO ER308, OR EQUIVALENT.
6. INSTALL ITEM 8 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84262 FOR WELDING HOOPS TO RIM.
7. STRUT MEMBER ON FWD END OF BASKET.
8. FINISH WITH BRUSHED CLEAN, AND POWDER COAT BASKET ASSEMBLY.

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	25 JAN 08
1	ADDED = ASSEMBLY	RR	25 MAR 08
2	CHANGED HANDLE BRACKETS	BJC	27 JAN 10
3	TITLE BLOCK UPDATED, WELDING ROD UPDATED, REFERENCE DMS ADDED	RR	11/07/2010
4	CENTRE HOOP MOVED, SPACER (7) MOVED, CAP (10) ADDED		



DETAIL B

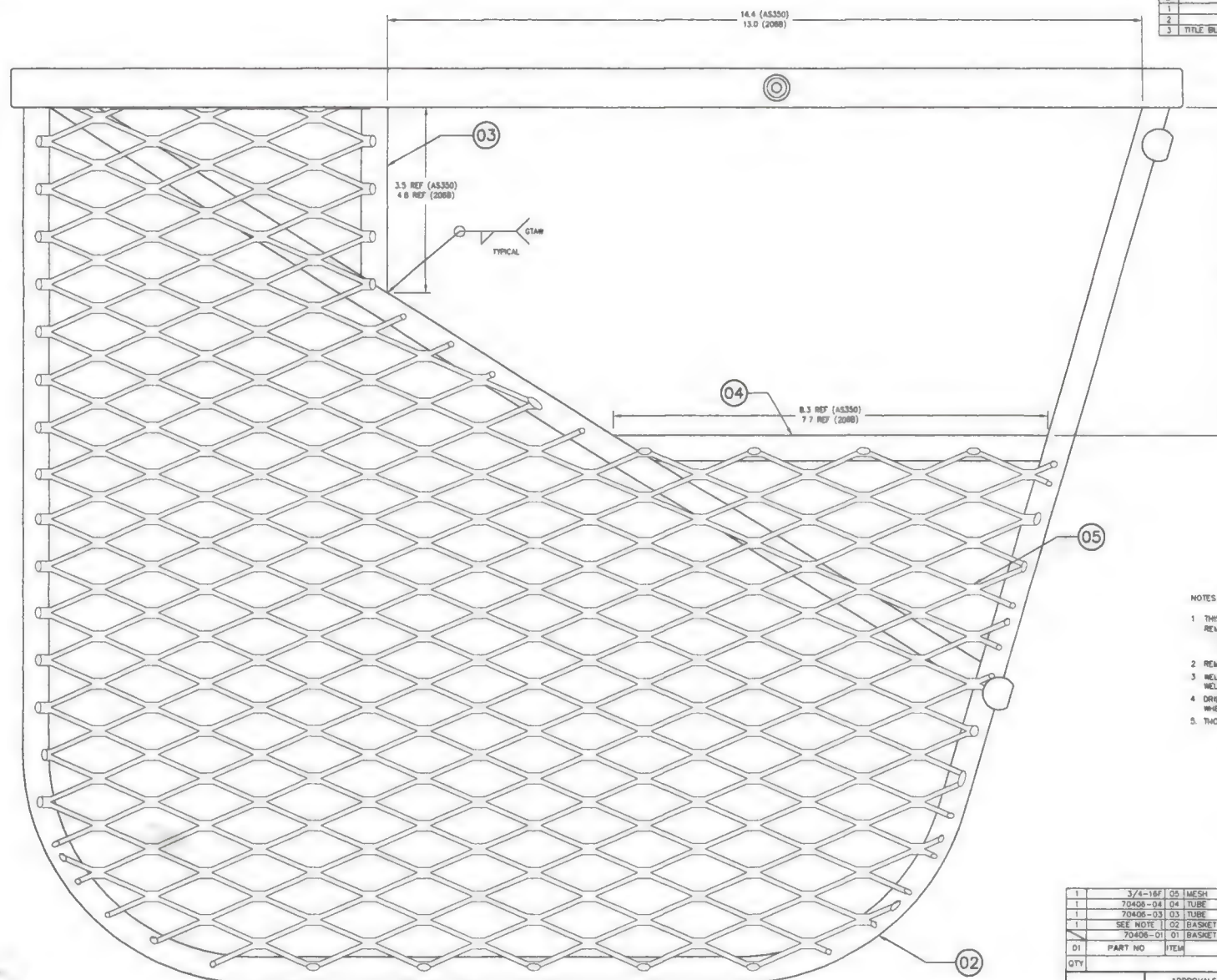
SCALE 1:1  
VIEW LOOKING AT INNER SURFACE OF BAKSET



1		1		--		10		CAP		MILD STEEL		A/S 10/10/20		0.5 X 0.035 SQR TUBE	
A/R		1		3/4 - 16F		09		MESH		MILD STEEL		COMMERCIAL			
1		1		84262-01		08		BASKET HANDLE PROVISIONS ASSEMBLY							
1		1		49215-01		07		SPACER							
3		3		76421-01		06		HOOK							
1		1		76423-01		05		ATTACHMENT HOOP							
1		1		76422-01		04		ATTACHMENT HOOP							
A/R		A/R				03		SQUARE TUBE		4130 STEEL COND N		ML-7-6736		0.5 X 0.035 SQR TUBE	
A/R		A/R				02		SQUARE TUBE		4130 STEEL COND N		ML-7-6736		0.75 X 0.035 SQR TUBE	
1		1		76411-01-02		-01-02		BASKET BODY ASSEMBLY - LH							
1		1		76411-01-01		-01-01		BASKET BODY ASSEMBLY - RH							
-01-02		-01-01		PART NO		ITEM		DESCRIPTION		MATERIAL/NOTE		MATERIAL SPEC		STOCK SIZE	
QTY		LIST OF MATERIALS													

APPROVALS		DATE	 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, B.C. CANADA, V8A 0G3 TEL. 604-465-5270    WWW.AERODSIGN.CA			
DRAWN	R RATHWELL	23 JAN 08				
CHECKED	E BURCHIN					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON			<b>EUROCOPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>BASKET BODY ASSEMBLY (MEDIUM)</b>			
DECIMALS		ANGLES				
I.X.X. ±0.010		±1/2°				
I.X.X. ±0.03						
I.X.X. ±0.1			SCALE 1 4	ENG. SIZE	ENG. NO.	REV
SHEET 1 OF 1			<b>A1</b>	<b>76411</b>	<b>3</b>	

2016-69



(01) BASKET BODY ASSEMBLY  
EUROCOPTER AS350 SHORT/MEDIUM SHOWN  
BELL 208B SIMILAR

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL 208B	BUC	DEC 22/08
2	MODIFY OPENING	BUC	OCT 27/11
3	TITLE BLOCK UPDATED; LONG/EXTRA LARGE CONFIGURATION ADDED TO SHIT. 2	BUC	11/07/2014

## NOTES

- THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY. REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH THE FOLLOWING DRAWING:  
EUROCOPTER AS350/AS350: 78411 (MEDIUM) OR 77811 (SHORT)  
BELL 208B: 80311 OR 80311
- REMOVE ALL BURRS AND BREAK SHARP EDGES
- WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2883C  
WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
- DRILL #30 (0.125) HOLES TO VENT TUBES INTO BASKET HOOP AND/OR RIM  
WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
- THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

1	3/4-16F	05	MESH	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	70406-04	04	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	70406-03	03	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE	02	BASKET BODY ASSEMBLY			
1	70406-01	01	BASKET BODY ASSEMBLY - MODIFIED FORWARD END			
D1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
APPROVALS				DATE		
DRAWN: JEFF CLARKE				19 MAR 2008		
CHECKED: E BURGIN						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				 <b>AERO DESIGN LTD.</b> 9889A MALASPINA ROAD POWELL RIVER, CANADA, V8A 0G3 TEL. 866 463 5578 www.aerodesign.co		
DECIMALS						
X.XXX ±0.010						
X.XX ±0.03						
X.X ±0.1						
SHEET 1 OF 2				SCALE 1:1		
A1				DWS SIZE		DWS NO
70406				REV		3



AERO DESIGN LTD.

8888A MALASPINA ROAD  
POWELL RIVER BC, CANADA V8A 0G3  
TEL: 804 485 3276 www.aerodesign.ca

QUICK RELEASE CARGO BASKET  
OPEN FORWARD END MODIFICATION







## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76421-01	
Aircraft:	Eurocopter	Model: AS350
Description:	Hoop, Short/Medium/Long	
Supplier:	Aero Design Ltd	
Color:	N/A	
WO#:	2016-22	PO# 15072





## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
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Color:	N/A	
WO#:	2016-22	PO# 15072



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76421-01 with 84262-01	
Aircraft:	Airbus	Model: AS350
Description:	Basket Hoop with Handle Provisions, Med	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A

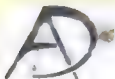




## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76423-01	
Aircraft:	Airbus	Model: AS350
Description:	Cargo Basket Hoop, Medium	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-47	PO# N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

**Quantity:** 1

**PN:** 76423-01

**Aircraft:** Airbus

**Model:** AS350

**Description:** Cargo Basket Hoop, Medium

**Supplier:** Aero Design Ltd.

**Color:** N/A

**WO#:** 2016-47

**PO#** N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76422-01	
Aircraft:	Airbus	Model: AS350
Description:	Cargo Basket Hoop, fwd	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A





## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76422-01	
Aircraft:	Airbus	Model: AS350
Description:	Cargo Basket Hoop, fwd	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

**Quantity:** 1

**PN:** 76422-01

**Aircraft:** Airbus

**Model:** AS350

**Description:** Cargo Basket Hoop, fwd

**Supplier:** Aero Design Ltd.

**Color:** N/A

**WO#:** 2016-68

**PO#** N/A



## **Aero Design Ltd.**

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V8A 0G3, 604-483-AERO (2376)

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Aircraft:	Airbus	Model: AS350
Description:	Cargo Basket Hoop, Medium	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-47	PO# N/A





## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76421-01 with 84262-01	
Aircraft:	Airbus	Model: AS350
Description:	Basket Hoop with Handle Provisions, Med	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	76421-01 with 84262-01	
Aircraft:	Airbus	Model: AS350
Description:	Basket Hoop with Handle Provisions, Med	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A



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9888 A Malaspina Rd., Powell River, BC  
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Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A





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Description:	Cargo Basket Hoop, fwd	
Supplier:	Aero Design Ltd.	
Color:	N/A	
WO#:	2016-68	PO# N/A



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